

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005771**Date Inspected:** 19-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 630**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xuxian Ping, Wang Wei Ming**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Assembly, Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Joe Alaniz was present during the times noted above for observations relative to the work being performed.

This QA Inspector performed Ultrasonic Testing (UT) on approximately 15% of CJP on the OBG 7E and OBG 1AA Segment welds previously accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3. The QA Inspector observed no rejectable indications at the time of testing. The QA Inspector generated a TL-6027 UT report on this date. Welds UT verified were identified as listed below

Bay 14
SEG042A-002/003

Bay 10
SEG1E-584

This QA Inspector observed the following work in progress:

Bay 7

ZPMC's qualified welding personnel's identified as Mr. Jia Anquan (201725), Mr. Chen Dingding (0048923), Mr. Wang Fei (051786) perform SMAW tack welding on weld joints identified SP384-001-013,014 and 015. ZPMC QC identified Mr. Wang Wei Ming was present to monitor the welding process. The welding parameters as

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2112.

ZPMC's qualified welding personnel's are identified as Mr. Li Shuliang (048801) and Mrs. He Yumei (048625) perform FCAW welding on weld joint identified as SP113-001-048,049, SP140-001-039 and 040. ZPMC QC identified Mr. Chen Ying Xin was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-B-U2-F and WPS-B-T-2233-B-U2-F.

Bay 6

ZPMC welding personnel Mr. Li Shugiang (053609) perform FCAW welding on weld joint identified as WD1-CBSA3-1-2-32, 7, 8 and 5. ZPMC QC identified Mr. Zhao Chen Sun was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2133 and WPS-B-T-2132.

Bay 3

ZPMC qualified welding personnel identified as Mr. Zhu Jialiang (200583) perform SMAW welding on weld joints identified FB024-007-0811-031, 028, and 029. ZPMC QC identified Mr. Wang Wei Ming was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2112.

Bay 11

ZPMC qualified welding personnel identified as Mr. Li Xiuchun (040733) perform SMAW tack welding on weld joints identified WSD1-TL6B/L-4A. ZPMC QC identified Mr. Li Ming was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2214-C-U2.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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